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(54) **CURABLE SOLID INKS CONTAINING  
CYCLOHEXYL-BASED CRYSTALLINE  
GELLANTS**

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(51) **Int. Cl.**

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**C09D 11/00** (2014.01)

**C09D 11/34** (2014.01)

(52) **U.S. Cl.**

CPC ..... **C09D 11/00** (2013.01); **C09D 11/34**  
(2013.01)

(58) **Field of Classification Search**

CPC ..... C09D 11/34

USPC ..... 106/31.29, 31.61

See application file for complete search history.

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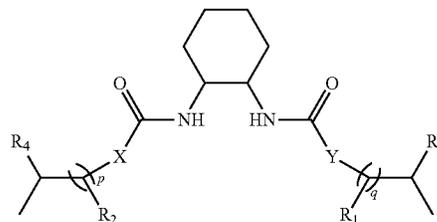
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(57) **ABSTRACT**

Disclosed herein are curable solid inks which are solid at  
room temperature and molten at an elevated temperature at  
which the molten ink is applied to a substrate. In particular,  
the curable solid ink of the present embodiments comprises a  
cyclohexyl-based crystalline gellant that impart self-leveling  
capabilities to the inks, where the cyclohexyl-based crystal-  
line gellant have a structure of Formula I:

Formula I



wherein each X, Y, p, q, R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, and R<sub>4</sub> are as defined  
herein.

**19 Claims, 6 Drawing Sheets**

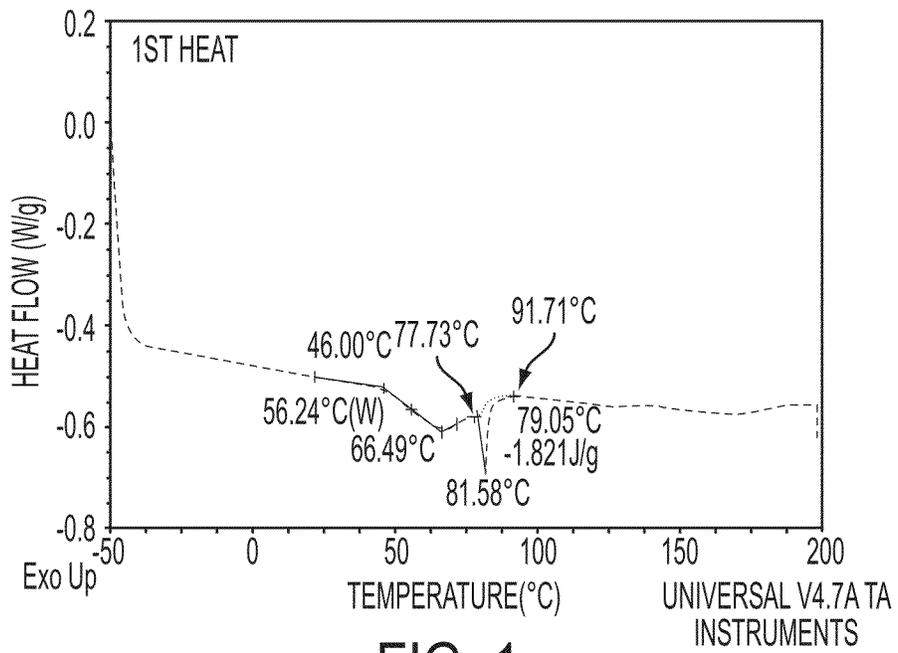


FIG. 1

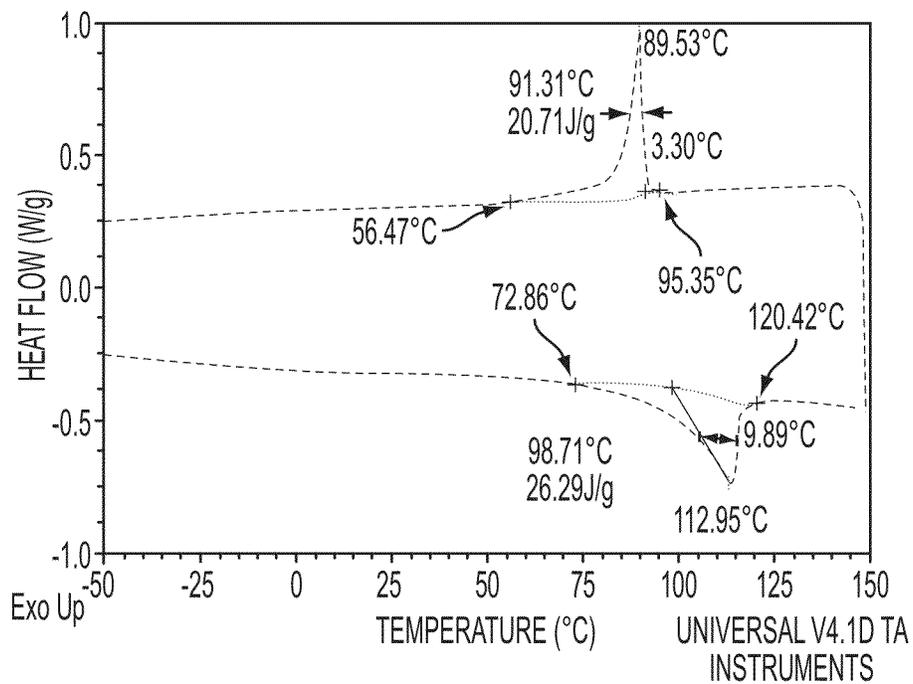


FIG. 2

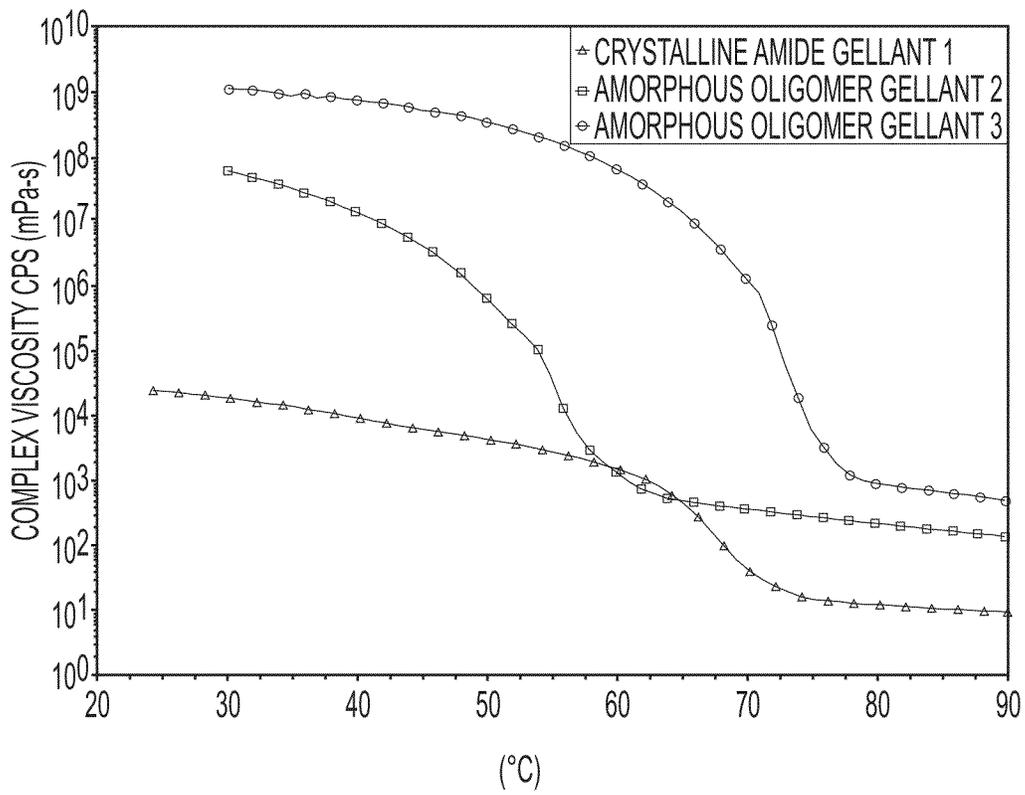


FIG. 3

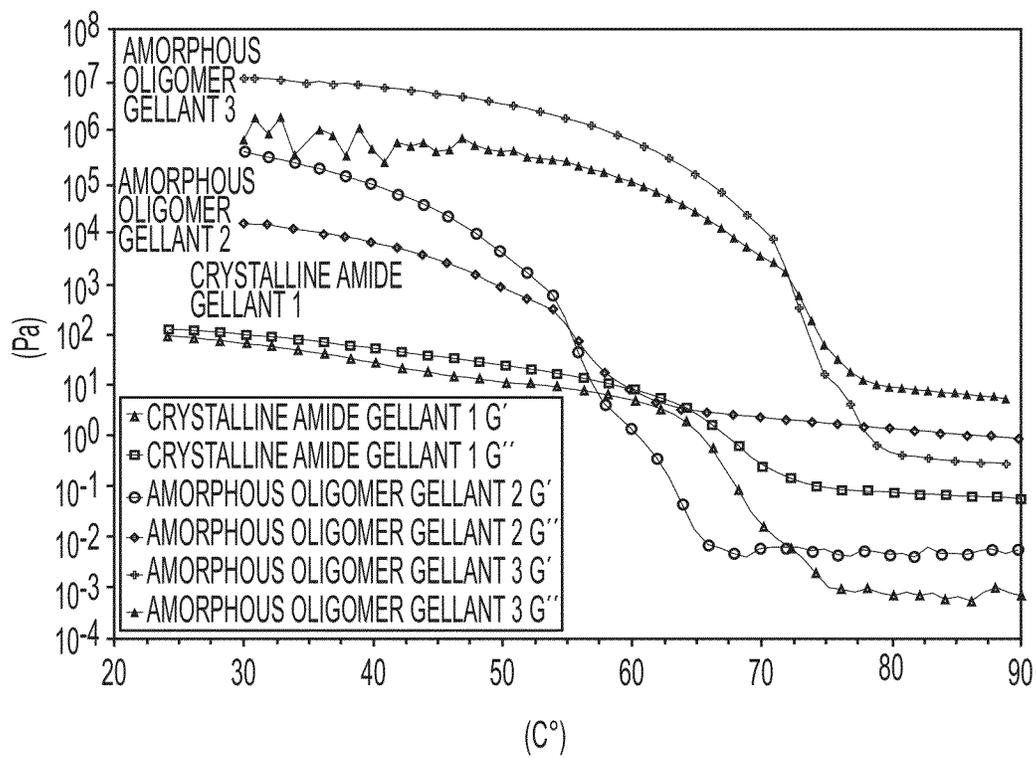
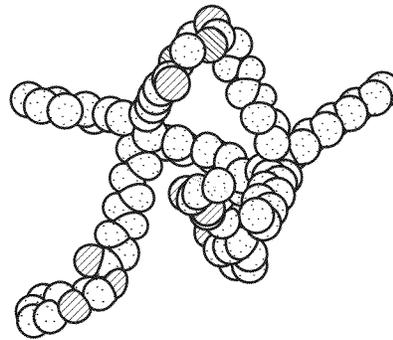
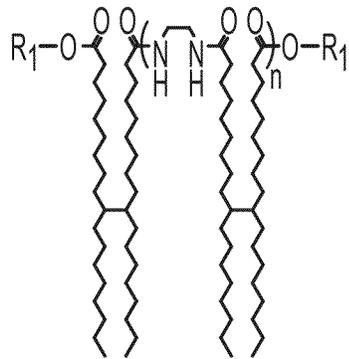


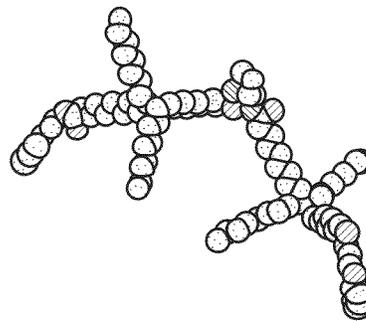
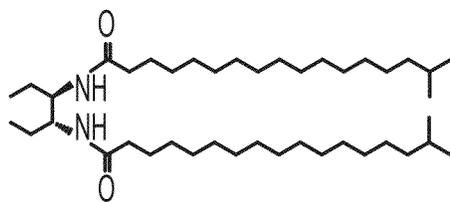
FIG. 4



WHEREIN R1 IS PHENYLETHYL,  
N IS 1 TO 10

AMORPHOUS OLIGOMER GELLANT 2

FIG. 5



CRYSTALLINE AMIDE GELLANT 1

FIG. 6

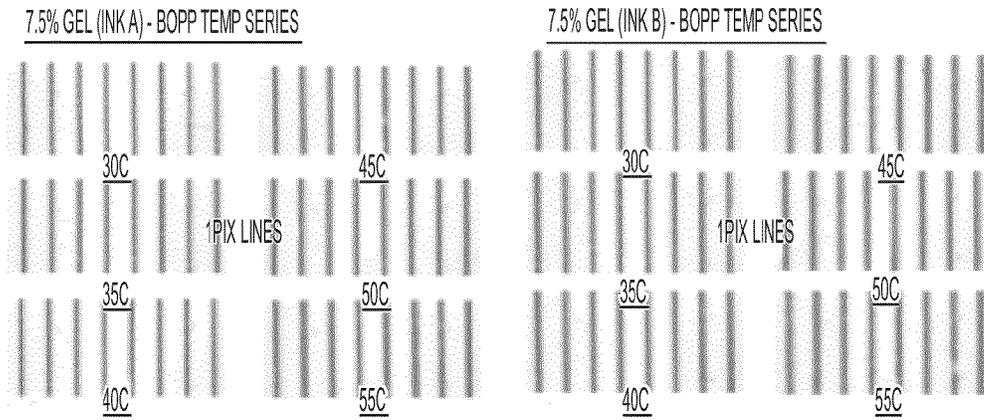


FIG. 7

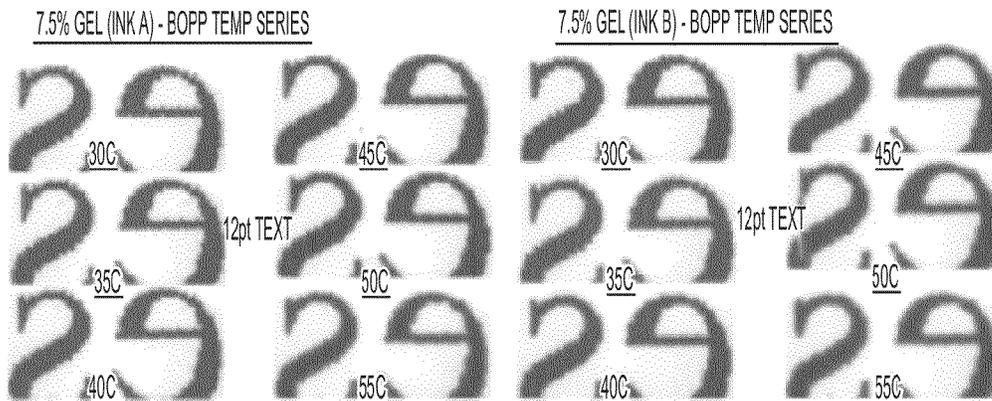


FIG. 8

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# CURABLE SOLID INKS CONTAINING CYCLOHEXYL-BASED CRYSTALLINE GELLANTS

## BACKGROUND

The present embodiments relate to phase change ink compositions that can be used for ink jet printing in a variety of applications. A relatively new type of phase change ink is an ultraviolet (UV) curable solid ink. A UV curable solid ink is characterized by being a gel-like consistency at room temperature and a low viscosity liquid at an elevated temperature for jetting on a substrate. When the ejected ink hits the substrate, it changes phase from the liquid back to its more viscous gel consistency. Because these gel inks solidify rapidly upon cooling, these inks have advantages over water or solvent-based inks that may de-wet from many surfaces, such as plastics, cardboard, and the like. Once the gel ink is exposed to UV radiation, the ink is cured to form a cross-linked polymer matrix resulting in a very hard and durable mark on the substrate.

There remains a desire to level or spread the ink to reduce the so-called "corduroy" effect and achieve more uniform gloss, mask missing jets, and thinner layers required for applications such as packaging. Conventional leveling methods and devices, however, cannot be used with the gel inks due to their unique properties. Since these inks have a paste-like consistency, the inks have very little cohesive strength prior to curing. In addition, the inks are designed such that they have good affinity to many materials. As a result, conventional methods for flattening a layer of ink tend to fail when used with the UV gel ink because the ink will stick to the leveling device and undergo cohesive failure (i.e. splits) leaving residual ink behind on the leveling device. It is not possible to flatten the ink after it has cured either because the polymerized material is extremely tough and non-yielding.

Ampo, K. et al. "Leveling Viscous Fluids Using Ultrasonic Waves", *JJAPS*, (2004), vol 43, pp 2857-2861 describes a method for leveling viscous fluids, in this case a photoresist material, on substrates using ultrasound techniques. In this paper, it has been proposed that such a method may be advantageous over traditional coating methods such as slit nozzle methods (due to unevenness and orientation dependence), and spin-coating (challenging for large substrates and wasteful, due to spilling off of the edges). The paper describes experiments done to level a photoresist material with a viscosity of 10 cps coated onto a non-porous substrate. However, this paper does not address how one could level a viscous gel ink (with viscosity of 10<sup>6</sup> cps). Moreover, there are no teachings in this publication on how one would level a viscous gel ink on a substrate such as paper.

U.S. Pat. No. 5,376,402 which is hereby incorporated by reference herein in its entirety, describes, in embodiments, an ultrasonically assisted coating method for applying a smooth layer of coating material on a surface of a moving web. In this patent, the coating material is deposited using a die onto a moving web, where the ultrasonic energy generator is applying ultrasonic energy in a variety of modes, directly to the web, to the die itself, and through the air. However, this patent only describes materials deposited by 'contact' approaches, such as slot-fed knife coating, roll-coating, and extrusion coating. Furthermore in the single example cited in the patent, the highest viscosity material tested was a solvent-based rubber coating with a viscosity of 5,000 cps, at a thickness of 63.5

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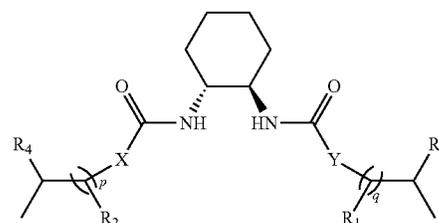
um. Thus, this reference does not address how one would level a viscous gel ink on a substrate.

Thus, there exists a need for a non-contact approach to level the images printed with gelled UV inks prior to curing. The present embodiments are thus directed to curable gel inks, and more particularly, UV curable gel inks and methods specially adapted for leveling these inks on substrates.

## SUMMARY

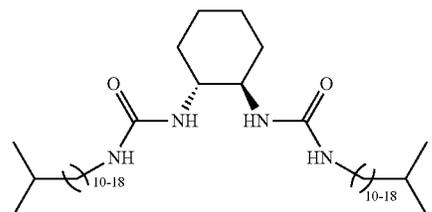
According to embodiments illustrated herein, there is provided a self-leveling curable solid ink comprising a curable wax; a cyclohexyl-based crystalline gellant (or referred to as "crystalline gellant"); wherein the cyclohexyl-based crystalline gellant has a tan  $\delta$  above about 0.08, and a melting point of above about 100° C.

In particular, the present embodiments provide a self-leveling curable solid ink comprising a curable wax; a cyclohexyl-based crystalline gellant; and a photoinitiator; wherein the cyclohexyl-based crystalline gellant has the following formula:



wherein each X and Y is independently CH<sub>2</sub>, NH or O; each p and q is independently from about 8 to about 20; each R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> is independently H or lower alkyl; and wherein the cyclohexyl-based crystalline gellant has a tan  $\delta$  above about 0.08, and a melting point of above about 90° C.

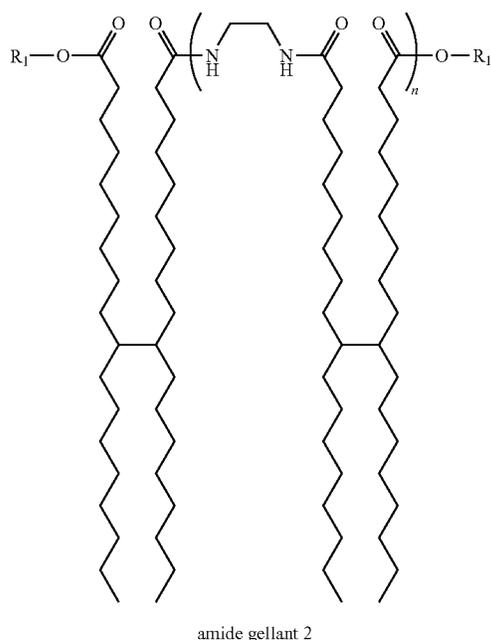
In further embodiments, the present embodiments provide a self-leveling curable solid ink comprising a curable wax; and a cyclohexyl-based crystalline gellant; wherein the cyclohexyl-based crystalline gellant has the following formula:



## BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a graph showing the differential scanning calorimetry (DSC) of a traditional amorphous oligomer gellant 2. The structure of the amorphous oligomer gellant 2 is shown below:

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wherein  $R_1$  is  $\text{CH}_2\text{CH}_2\text{OC}_6\text{H}_5$ , and  $n$  is an integer ranging from 1-10.

FIG. 2 is a graph showing the differential scanning calorimetry (DSC) of a crystalline amide gellant 1 of the present embodiments.

FIG. 3 is a graph showing rheological properties (complex viscosity vs. temperature) of a traditional amorphous oligomer gellant 2 and a crystalline amide gellant 1.

FIG. 4 is a graph showing the overlay of storage ( $G'$ ) and loss ( $G''$ ) moduli for a crystalline amide gellant 1, an amorphous oligomer gellant 2, and an amorphous oligomer gellant 3. The magnitude of the values and the ratio  $\tan \delta = G''/G'$  of the crystalline amide gellant 1 is much higher at room temperature compared to the two amorphous gellants 2 and 3.

FIG. 5 is a 3-D structure of the energy-minimized structure of a traditional amorphous oligomer gellant 2.

FIG. 6 is a 3-D structure of the energy-minimized structure of a crystalline amide gellant 1 of the present embodiments.

FIG. 7 is a micrograph showing a print comparison of line uniformity for a traditional curable solid ink and a curable solid ink made according to the present embodiments.

FIG. 8 is a micrograph showing a print comparison of character smoothness for a traditional curable solid ink and a curable solid ink made according to the present embodiments.

### DETAILED DESCRIPTION

In the following description, it is understood that other embodiments may be utilized and structural and operational changes may be made without departure from the scope of the present embodiments disclosed herein.

Solid ink technology broadens printing capability and customer base across many markets, and the diversity of printing applications will be facilitated by effective integration of printhead technology, print process and ink materials. As discussed above, while current ink options are successful for printing on various substrates, there is still a need to achieve a non-contact approach to level a UV curable gel ink prior to curing.

The present embodiments are directed generally to ultraviolet (UV) curable solid inks. In particular, the present embodiments provide curable solid inks that exhibit properties that allow the inks to self-level in the printed ink images

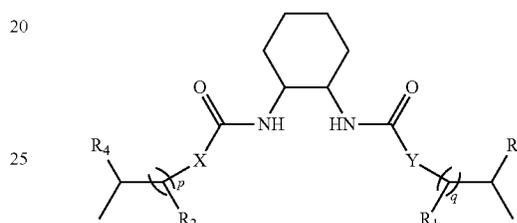
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prior to curing, and methods for making the same. Unlike the traditional curable solid inks that contain amorphous oligomer gellants (e.g., an ester-terminated oligoamide based in dimer acids and ethylene diamine) with glass-transition temperature  $T_g$  of from about  $30^\circ\text{C}$ . to about  $75^\circ\text{C}$ ., or from about  $50^\circ\text{C}$ . to about  $60^\circ\text{C}$ ., these curable solid inks contain amide gellant compounds that exhibit crystalline behavior with melting point above  $90^\circ\text{C}$ ., or from about  $90^\circ\text{C}$ . to about  $150^\circ\text{C}$ ., or from about  $100^\circ\text{C}$ . to about  $120^\circ\text{C}$ .

The curable solid inks of the present embodiments have reduced phase-transition temperatures and tuned viscoelastic properties, which has been discovered to impart the self-leveling capability and does not require physical contact to level.

The crystalline gellant compound of the present embodiments have the following formula:

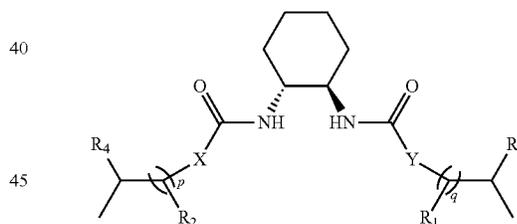
Formula I



wherein each X and Y is independently  $\text{CH}_2$ , NH or O; each p and q is independently from about 8 to about 20; each  $R_1$ ,  $R_2$ ,  $R_3$ , and  $R_4$  is independently H or lower alkyl, such as methyl, ethyl, propyl.

In certain embodiments, the disclosure provides a crystalline gellant compound having following formula:

Formula II



wherein each X, Y, p, q,  $R_1$ ,  $R_2$ ,  $R_3$ , and  $R_4$  are as defined above.

In certain embodiments, the disclosure provides a crystalline amide gellant compound wherein X is  $\text{CH}_2$ . In certain embodiments, the disclosure provides a crystalline urea gellant compound wherein X is NH. In certain embodiments, the disclosure provides a crystalline urethane gellant compound wherein X is O. In certain embodiments, the disclosure provides a crystalline amide gellant compound wherein Y is  $\text{CH}_2$ . In certain embodiments, the disclosure provides a crystalline urea gellant compound wherein Y is NH. In certain embodiments, the disclosure provides a crystalline urethane gellant compound wherein Y is O. In certain embodiments, X is the same as Y.

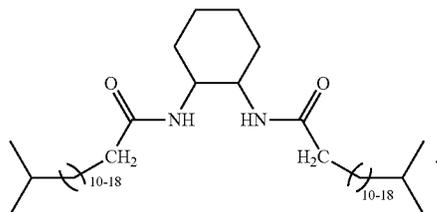
In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound wherein each  $R_1$  and  $R_2$  is independently H or methyl. In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound wherein each one of  $R_1$  is H. In certain embodiments, the disclosure provides a cyclohexyl-based crystalline

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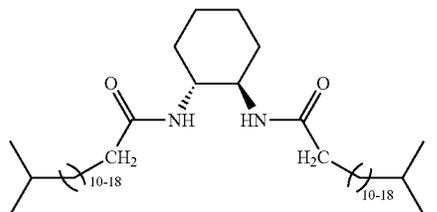
gellant compound wherein each one of R<sub>2</sub> is H. In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound wherein R<sub>3</sub> is methyl. In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound wherein R<sub>4</sub> is methyl.

In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound, wherein p is from about 10 to about 18, or from about 12 to about 16. In one embodiment, p is about 14. In certain embodiments, the disclosure provides a cyclohexyl-based crystalline gellant compound wherein q is from about 10 to about 18, or from about 12 to about 16. In one embodiment, q is about 14.

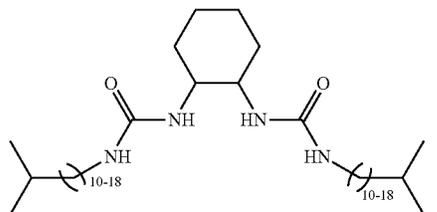
In one embodiment, the disclosure provides a crystalline amide gellant compound having the following formula:



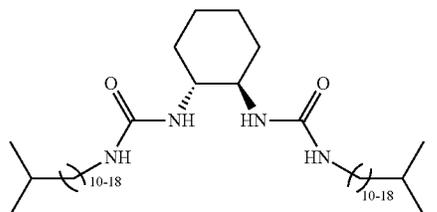
In one embodiment, the disclosure provides a crystalline amide gellant compound having the following formula:



In one embodiment, the disclosure provides a crystalline urea gellant compound having the following formula:

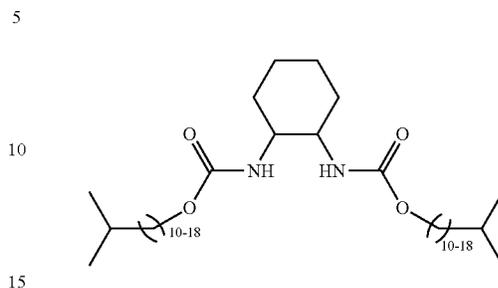


In one embodiment, the disclosure provides a crystalline urea gellant compound having the following formula:

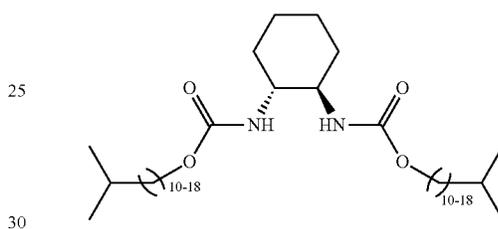


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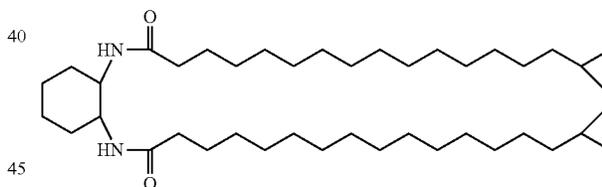
In one embodiment, the disclosure provides a crystalline urethane gellant compound having the following formula:



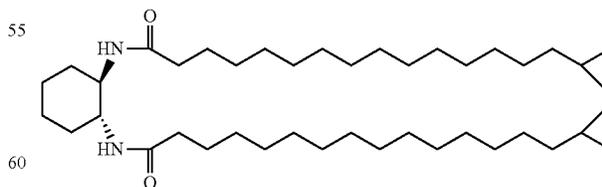
In one embodiment, the disclosure provides a crystalline urethane gellant compound having the following formula:



In a specific embodiment, the disclosure provides a crystalline amide gellant compound having the following formula:

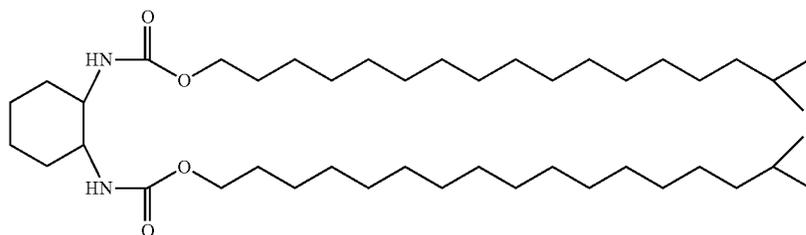


In a further specific embodiment, the disclosure provides a crystalline amide gellant compound having the following formula:

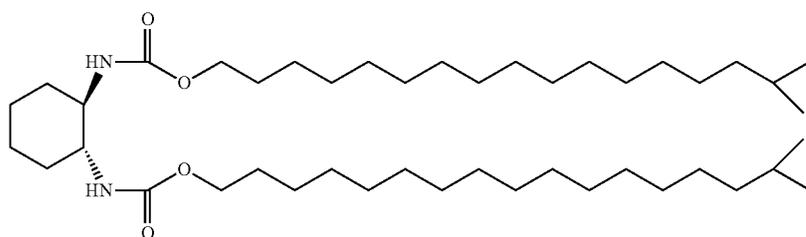


Crystalline Amide Gellant 1

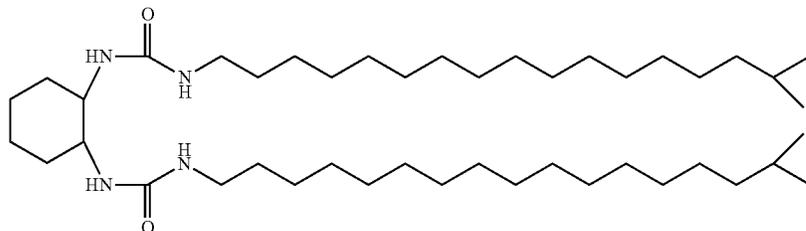
In a specific embodiment, the disclosure provides a crystalline urethane gellant compound having the following formula:



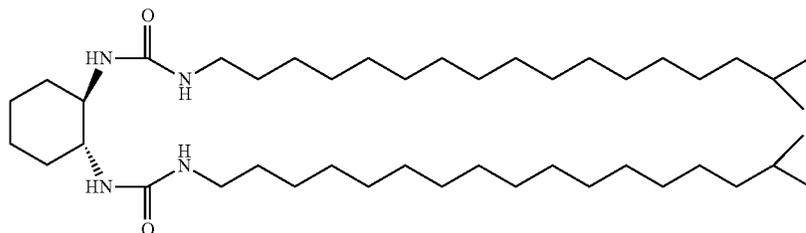
In a further specific embodiment, the disclosure provides a crystalline urethane gellant compound having the following formula:



In a specific embodiment, the disclosure provides a crystalline urea gellant compound having the following formula:



In a further specific embodiment, the disclosure provides a <sup>45</sup> crystalline urea gellant compound having the following formula:

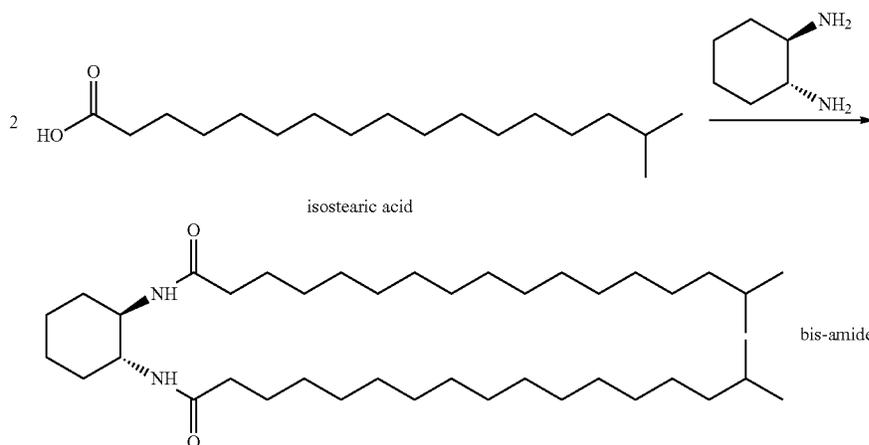


<sup>60</sup>

The crystalline amide gellant of Formula I can be prepared by the reaction of about one equivalent of a diamine and about two equivalents of an acid. The crystalline urea gellant of Formula I can be prepared by the reaction of about one <sup>65</sup> equivalent of a diamine and about two equivalents of a cyanate. The crystalline urethane gellant of Formula I can be

prepared by the reaction of about one equivalent of a diamine and about two equivalents of an alcohol. Suitable diamines include trans-1,2-diaminocyclohexane. Suitable acids include isostearic acid.

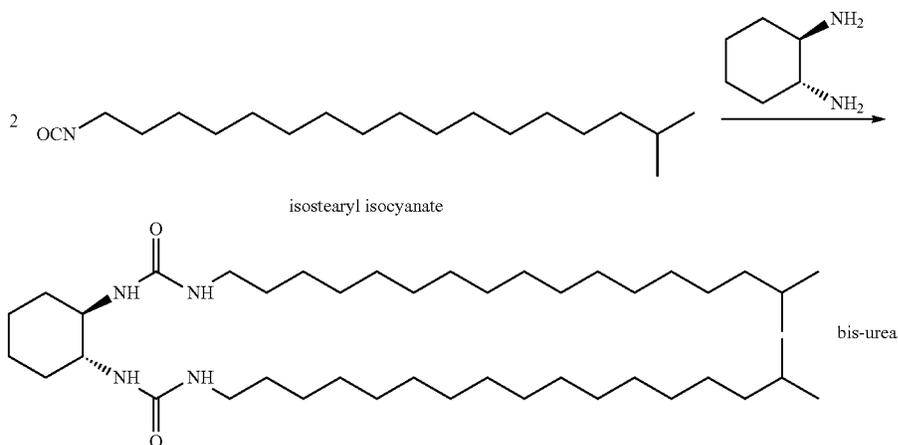
In a specific embodiment, the crystalline amide gellant compound of the present embodiments can be prepared from the following general scheme.



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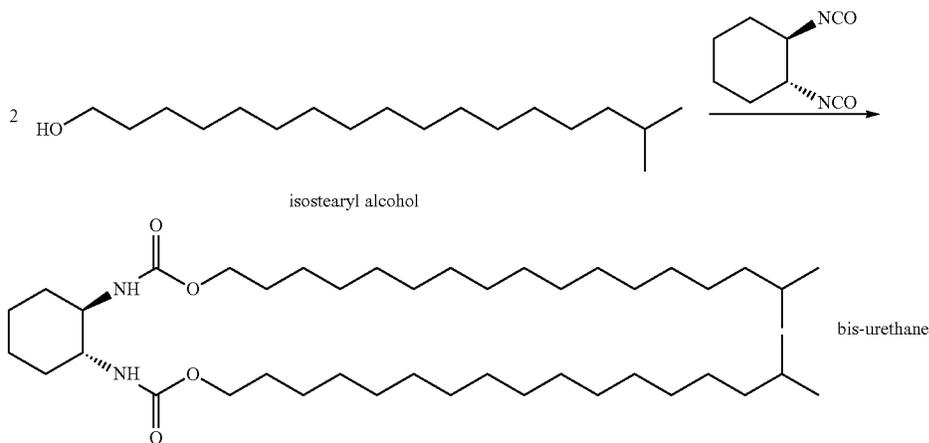
In a specific embodiment, the crystalline urea gellant compound of the present embodiments can be prepared from the following general scheme.

Stable jetting is a qualitative measurement that refers to the performance of the ink in a piezoelectric printhead. Characteristics of stable jetting include uniformity of drop volumes



In a specific embodiment, the crystalline urethane gellant compound of the present embodiments can be prepared from the following general scheme.

(i.e., 30 pL), over a range of frequencies, from 24 kHz to 48 kHz, and is manifested in solid lines on the printed page, with little to no jet drop-out which can be seen as dotted lines on the



printed page. Controlled showthrough refers to the degree of "haloing" that occurs in which the liquid components of the ink, such as, the monomer, pigment dispersion, etc., pool out and soak into the page. Controlled showthrough is relevant only on porous substrates such as paper and cardboard, but not on foils or plastics, which are non-porous. Showthrough measurements are made by using a spectrodensitometer and measurements are made on the printed colour image (front side), and compared to the backside of the printed page.

The storage ( $G'$ ) and loss ( $G''$ ) moduli of the crystalline gellant, which also captures the specific example of 'crystalline amide gellant' are sub-components of complex viscosity and provide a quantitative measure of how rubbery and inelastic the gels are. It has been discovered that lower molecular weight gellants have lower  $G''$  values than  $G'$  values at lower temperatures, which is reflected in the  $\tan \delta$  or ratio of  $G''/G'$ . The crystalline gellant of the present disclosure has a  $G'$  at room temperature of from about 1 Pa to about 100 Pa, and at 90 C from about  $10^{-2}$  Pa to about  $10^{-5}$  Pa, and a  $G''$  at room temperature of from about 1 Pa to about 100 Pa, and at 90 C from about  $10^{-1}$  Pa to about  $10^{-3}$  Pa.

The gel point is defined as the crossover point of  $G''/G'$ . The optimal gel point is dependent on the substrate, as heat dissipations vary. The optimal gel point ranges of the inks according to some embodiments is between ambient room temperature and 70° C., between 30° C. and 60° C., or between 40° C. and 50° C., although the gel point can be outside of these ranges. The gel point is defined as the point in a temperature-step dynamic viscosity measurement where  $\tan \delta$  (or  $\tan \delta$ ) is equal to 1.  $\tan \delta$  is a unitless computed value defined by the following equation:

$$\tan \delta = G''/G'$$

where  $G''$  is the viscous or loss modulus (in Pa) and  $G'$  is the storage or elastic modulus (in Pa). Furthermore, when the  $\tan \delta$  ratio is  $<1$ ,  $G''$  (loss modulus) is less than  $G'$  (storage modulus) and the material is defined as a gel. Conversely, when the  $\tan \delta$  ratio is  $>1$ ,  $G''$  (loss modulus) is greater than  $G'$  (storage modulus) and the material is no longer a gel.  $\tan \delta > 1$  is the viscous (non-gel) state and  $\tan \delta < 1$  is the elastic (gel) state.

Generally, crystalline gellants have higher  $\tan \delta$  than amorphous gellants. The crystalline gellants of the present embodiments have a higher  $\tan \delta$  than the oligomer gellants. The crystalline gellants of the present embodiments have a  $\tan \delta$  of higher than about 0.08, 1, or about 1.3. In certain embodiments, the crystalline gellants have a  $\tan \delta$  of from about 0.8 to about 2, from about 1 to about 1.8, or from about 1 to about 1.6. In a specific embodiment, the amide gellant compounds have a  $\tan \delta$  of about 1.487. Typically, the oligomer gellants have a much lower  $\tan \delta$  of below about 0.08, or in the range of from about 0.039 to about 0.058. The crystalline gellants of the present embodiments behave more as a viscous material than a rubbery gel, this is linked to its ability to self-level in an ink.

#### Curable Inks

The ink compositions of the present embodiments comprise a cyclohexyl-based crystalline gellant disclosed herein. The present disclosure also relates to curable inks comprising a cyclohexyl-based crystalline gellant of the present embodiments.

In some embodiments, the ink compositions of the present embodiments may be solid inks. Solid ink technology broadens printing capability and customer base across many markets, and the diversity of printing applications will be facilitated by effective integration of printhead technology, print process and ink materials. The curable solid ink compositions are characterized by being solid at room temperature, for example, 20-50° C. or 20-27° C., and molten at an elevated temperature at which the molten ink is applied to a substrate. The ink compositions of the present embodiments may be solid curable inks at room temperature both in the presence and absence of a gellant.

In some embodiments, the ink compositions may further optionally comprise one or more of the following: curable waxes, colorants, and free-radical photoinitiators, and non-curable resins (e.g., viscosity modifiers).

The crystalline gellant may be present in the curable solid ink in an amount of from about 1 percent to about 50 percent, from about 1 percent to about 30 percent, from about 2 percent to about 20 percent, from about 5 percent to about 15 percent, and from about 5 percent to about 10 percent by weight of the ink.

A curable wax may be present in the curable solid ink in an amount of from about 0.1 to about 30 percent of the total weight of the curable solid ink. This includes from about 1 percent to about 30 percent, from about 1 percent to about 20 percent, and from about 5 percent to about 10 percent by weight of the ink.

A colorant may be present in the curable solid ink in an amount of from about 0.1 percent to about 10 percent, from about 1 percent to about 10 percent, from about 5 percent to about 10 percent, or from about 1 percent to about 5 percent by weight of the total weight of the curable solid ink.

A photoinitiator may be present in the curable solid ink in an amount of from about 0.5 percent to about 15 percent, from about 5 percent to about 15 percent, from about 1 percent to about 10 percent, from about 5 percent to about 10 percent, and from about 1 percent to about 5 percent by weight of the total weight of the curable solid ink.

The ink compositions can be prepared by any desired or suitable method. For example, each of the components of the ink carrier can be mixed together, followed by heating, the mixture to at least its melting point, for example from about 50° C. to about 140° C., 75° C. to about 120° C. and 80° C. to about 100° C. The colorant may be added before the ink ingredients have been heated or after the ink ingredients have been heated. When pigments are the selected colorants, the molten mixture may be subjected to grinding in an attritor or ball mill apparatus to effect dispersion of the pigment in the ink carrier. The heated mixture is then stirred for about 5 seconds to about 30 minutes or more, to obtain a substantially homogeneous, uniform melt, followed by cooling the ink to ambient temperature (typically from about 20° C. to about 25° C.). The inks are solid at ambient temperature. In a specific embodiment, during the formation process, the inks in their molten state are poured into molds and then allowed to cool and solidify to form ink sticks. Suitable ink preparation techniques are disclosed in U.S. Pat. No. 7,186,762, the disclosure of which is incorporated herein by reference in its entirety.

The ink compositions of the present embodiments may further optionally include one or more conventional additives to take advantage of the known functionality associated with such conventional additives. Such additives may include, for example, defoamer, slip and leveling agents, clarifier, viscosity modifier, adhesive, plasticizer and the like. When present, the optional additives may each, or in combination, be present in the ink in any desired or effective amount, such as from about 1 percent to about 10 percent, from about 5 percent to about 10 percent, or from about 3 percent to about 5 percent by weight of the ink.

In some embodiments, the ink compositions of the present embodiments may be liquid curable inks. In some embodiments, the ink compositions of the present embodiments may further comprise additional gellants, which includes both curable and non-curable gellants.

#### Properties of the Gellants and Inks

Prepared solid inks of the present embodiments have low jetting temperatures than previously achieved, for example, jetting temperatures of from about 100 to about 70° C., or from about 100 to about 80° C., from about 90 to about 70° C. In particular, the present embodiments also provide faster phase change characteristics, excellent curing performance, increased hardness after curing, and low shrinkage characteristics.

The solid inks of the present embodiments have an optimal gel point of between ambient room temperature and 70° C., or between 30 and 60° C., or between 40 and 50° C., although the gel point can be outside of these ranges. The values of differential showthrough of the present embodiments range from 0.01 to 0.15, or less than 0.10 arbitrary units. Differential showthrough and optical density measurements were made with an X-Rite 938 spectrodensitometer (available from X-Rite (Grand Rapids, Mich.)). Differential showthrough values disclosed represent the difference between underside showthrough and one-paper overside showthrough.

The present embodiments provide low energy ultraviolet (UV) curable pigmented solid inks with high reactivity and minimum shrinkage. These inks of the present embodiments contain a cyclohexyl-based crystalline gellant of the present embodiments and are formulated with viscosities in the range of less than 20 cPs at 90° C., or from about 20 to about 5 cPs at 90° C., or from about 15 to about 8 cPs at 90° C., and a shrinkage value of less than 3 percent, or from about 1 to about 3 percent. As used herein, the shrinkage value indicates the shrinkage of the ink upon cooling from a liquid state. In addition, these inks exhibit a hardness after curing much higher than conventional solid inks, such as those commercially available from Xerox Corporation or Océ North America. Significant improvements in curing rate and benchmarked hardness after curing was also shown for these inks as well as improved compatibility between components upon solidification. Extensive studies demonstrated that the concentration of non-curable resins should be less than 5 percent, or from about 1 to about 3 percent, or less than 1 percent by weight. Curing rates were obtained by plotting the hardness versus duration of exposure to UV light in s/ft (Fusions UV doped mercury D-bulb, 600 W/cm) and applying the following expressions:

$$y = m_1 + m_2 \cdot (1 - \exp(-m_3 x))$$

$$\text{Initial Hardness} = m_1$$

$$\text{Initial Slope} = m_2 \cdot m_3$$

$$\text{Final Hardness} = m_1 + m_2$$

where the initial slope is taken as the initial curing rate. The inks of the present embodiments display curing rates from about 130 to about 250 ft/s, such as from about 180 to about 250 ft/s or from about 200 to about 250 ft/s. Depending on the type of bulb used in the UV curable lamp, the characteristic output used for curing may be from about 200 nm to about 450 nm.

#### Curable Waxes

The inks of the present embodiments may comprise blends of curable waxes, monomers, a gellant oligomer mixture composition of the present embodiments, optional colorants, and free-radical photoinitiators, and optionally up to 5 percent by weight of non-curable resins, such as viscosity modifiers. The curable waxes, monomers, curable waxes, optional colorants, and free-radical photoinitiators are solid materials below about 40° C., or from below about 40 to below about 30° C., with little or no smell. These components were selected to achieve jetting at temperatures in the range of from about 70 to about 100° C., or from about 80 to about 100° C., or from about 70 to about 90° C. These solid inks thus have robust jetting at elevated temperatures with a viscosity of from about 5 to about 15 cPs, or from about 10 to about 15 cPs, or from about 8 to about 12 cPs at these temperatures, and are solid at room temperature which prevents excessive spreading or migration of the printed droplet on porous substrate. After printing, the compositions are cured to provide robust images.

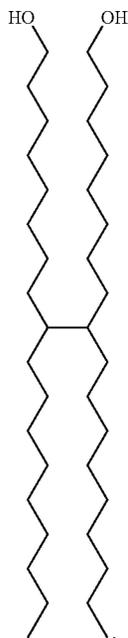
The curable solid inks of the present embodiments have a pre-cured hardness of from about 0.1 to about 11 or of from about 0.1 to about 5, or of from about 0.1 to about 3. These inks have a post-cured hardness of from about 85 to about 100, or of from about 90 to about 97, or of from about 93 to about 97. The curable solid components include monomers, curable waxes and a gellant oligomer mixture composition of the present embodiments. The curable wax may be a solid at room temperature (25° C.). Inclusion of the wax may promote an increase in viscosity of the ink composition as the composition cools from the application temperature. The curable wax may be any wax component that is miscible with the other components and that will polymerize to form a polymer. The term wax includes, for example, any of the various natural, modified natural, and synthetic materials commonly referred to as waxes.

Suitable examples of curable waxes include waxes that include or are functionalized with curable groups. The curable groups may include, for example, an acrylate, methacrylate, alkene, allylic ether, epoxide, oxetane, and the like. These waxes can be synthesized by the reaction of a wax, such as a polyethylene wax equipped with a carboxylic acid or hydroxyl transformable functional group.

Suitable examples of hydroxyl-terminated polyethylene waxes that may be functionalized with a curable group include mixtures of carbon chains with the structure  $\text{CH}_3 - (\text{CH}_2)_n - \text{CH}_2\text{OH}$ , where there is a mixture of chain lengths,  $n$ , where the average chain length can be in the range of about 16 to about 50, and linear low molecular weight polyethylene, of similar average chain length. Suitable examples of such waxes include, but are not limited to, the UNILIN series of materials such as UNILIN 350, UNILIN 425, UNILIN 550 and UNILIN 700 with Mn approximately equal to 375, 460, 550 and 700 g/mol, respectively. All of these waxes are commercially available from Baker-Petrolite. Guerbet alcohols, characterized as 2,2-dialkyl-1-ethanols, are also suitable compounds. Exemplary Guerbet alcohols include those containing about 16 to about 36 carbons, many of which are

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commercially available from Jarchem Industries Inc., Newark, N.J. PRIPOL® 2033 (C-36 dimer diol mixture including isomers of the formula

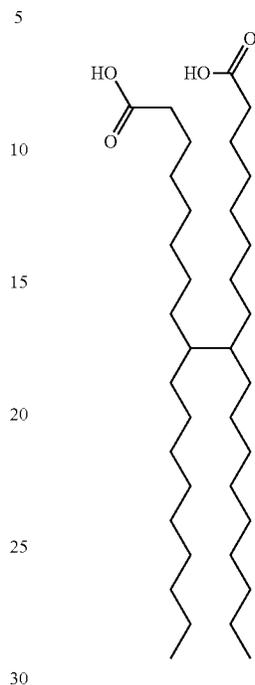


as well as other branched isomers that may include unsaturations and cyclic groups, available from Uniqema, New Castle, Del.; further information on C<sub>36</sub> dimer diols of this type is disclosed in, for example, "Dimer Acids," *Kirk-Othmer Encyclopedia of Chemical Technology*, Vol. 8, 4<sup>th</sup> Ed. (1992), pp. 223-237, the disclosure of which is totally incorporated herein by reference, may also be used. These alcohols can be reacted with carboxylic acids equipped with UV curable moieties to form reactive esters. Examples of these acids include acrylic and methacrylic acids, available from Sigma-Aldrich Co.

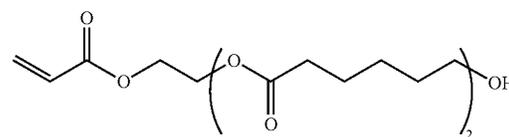
Suitable examples of carboxylic acid-terminated polyethylene waxes that may be functionalized with a curable group include mixtures of carbon chains with the structure CH<sub>3</sub>—(CH<sub>2</sub>)<sub>n</sub>—COOH, where there is a mixture of chain lengths, n, where the average chain length is about 16 to about 50, and linear low molecular weight polyethylene, of similar average chain length. Suitable examples of such waxes include UNICID® 350, UNICID® 425, UNICID® 550 and UNICID® 700 with M<sub>n</sub> equal to approximately 390, 475, 565 and 720 g/mol, respectively. Other suitable waxes have a structure CH<sub>3</sub>—(CH<sub>2</sub>)<sub>x</sub>—COOH, such as hexadecanoic or palmitic acid with x=14, heptadecanoic or margaric or daturic acid with x=15, octadecanoic or stearic acid with x=16, eicosanoic or arachidic acid with x=18, docosanoic or behenic acid with x=20, tetracosanoic or lignoceric acid with x=22, hexacosanoic or cerotic acid with x=24, heptacosanoic or carboce-ric acid with x=25, octacosanoic or montanic acid with x=26, triacontanoic or melissic acid with x=28, dotriacontanoic or lacceroic acid with x=30, tritriacontanoic or ceromelissic or psyllic acid, with x=31, tetratriacontanoic or geddic acid with x=32, pentatriacontanoic or ceroplastic acid with x=33. Guerbet acids, characterized as 2,2-dialkyl ethanoic acids, are also suitable compounds. Exemplary Guerbet acids include those containing 16 to 36 carbons, many of which are commercially

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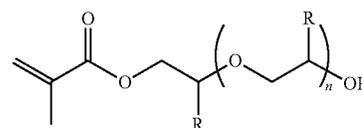
available from Jarchem Industries Inc., Newark, N.J. PRIPOL® 1009 (C-36 dimer acid mixture including isomers of the formula



as well as other branched isomers that may include unsaturations and cyclic groups, available from Uniqema, New Castle, Del.; further information on C<sub>36</sub> dimer acids of this type is disclosed in, for example, "Dimer Acids," *Kirk-Othmer Encyclopedia of Chemical Technology*, Vol. 8, 4<sup>th</sup> Ed. (1992), pp. 223-237, the disclosure of which is totally incorporated herein by reference, can also be used. These carboxylic acids can be reacted with alcohols equipped with UV curable moieties to form reactive esters. Examples of these alcohols include, but are not limited to, 2-allyloxyethanol from Sigma-Aldrich Co.;



SR495B from Sartomer Company, Inc. (Exton, Pa.); and



CD572 (R=H, n=10) and SR604 (R=Me, n=4) from Sartomer Company, Inc.

The curable wax can be included in the composition in an amount of from, for example, about 0.1 percent to about 30 percent by weight of the composition, such as from about 0.5 percent to about 20 percent or from about 0.5 percent to 15 percent by weight of the composition.

## Initiator

As mentioned above, the ink compositions may further optionally comprise an initiator, such as, for example, a photoinitiator. Such an initiator is desirable for assisting in curing of the ink. In embodiments, a photoinitiator that absorbs radiation, for example UV light radiation, to initiate curing of the curable components of the ink may be used. As the photoinitiator for ink compositions that are cured by free-radical polymerization, for instance, ink compositions containing acrylate groups or inks comprised of polyamides, mention may be made of photoinitiators such as benzophenones, benzoin ethers, benzil ketals,  $\alpha$ -hydroxyalkylphenones,  $\alpha$ -alkoxyalkylphenones  $\alpha$ -aminoalkylphenones and acylphosphine photoinitiators sold under the trade designations of IRGACURE and DAROCUR from Ciba. Specific examples of suitable photoinitiators include 2,4,6-trimethylbenzoyldiphenylphosphine oxide (available as BASF LUCIRIN TPO); 2,4,6-trimethylbenzoylthioacetophenone (available as BASF LUCIRIN TPO-L); bis(2,4,6-trimethylbenzoyl)-phenyl-phosphine oxide (available as Ciba IRGACURE 819) and other acyl phosphines; 2-methyl-1-(4-methylthio)phenyl-2-(4-morpholinyl)-1-propanone (available as Ciba IRGACURE 907) and 1-(4-(2-hydroxyethoxy)phenyl)-2-hydroxy-2-methylpropan-1-one (available as Ciba IRGACURE 2959); 2-benzyl 2-dimethylamino 1-(4-morpholinophenyl)butanone-1 (available as Ciba IRGACURE 369); 2-hydroxy-1-(4-(4-(2-hydroxy-2-methylpropionyl)benzyl)-phenyl)-2-methylpropan-1-one (available as Ciba IRGACURE 127); 2-dimethylamino-2-(4-methylbenzyl)-1-(4-morpholin-4-ylphenyl)-butanone (available as Ciba IRGACURE 379); titanocenes; isopropylthioxanthone; 1-hydroxy-cyclohexylphenylketone; benzophenone; 2,4,6-trimethylbenzophenone; 4-methylbenzophenone; diphenyl-(2,4,6-trimethylbenzoyl)phosphine oxide; 2,4,6-trimethylbenzoylphenylphosphinic acid ethyl ester; oligo(2-hydroxy-2-methyl-1-(4-(1-methylvinyl)phenyl)propanone); 2-hydroxy-2-methyl-1-phenyl-1-propanone; benzyl-dimethylketal; hydroxyalkylphenylketone (available as Fratelli Lamberti ESACURE KP<sub>150</sub>) and mixtures thereof. Mention may also be made of amine synergists, which are described as co-initiators that donate a hydrogen atom to a photoinitiator and thereby form a radical species that initiates polymerization (amine synergists can also consume oxygen dissolved in the ink—as oxygen inhibits free-radical polymerization its consumption increases the speed of polymerization), for example such as ethyl-4-dimethylaminobenzoate and 2-ethylhexyl-4-dimethylaminobenzoate. This list is not exhaustive, and any known photoinitiator that initiates the free-radical reaction upon exposure to a desired wavelength of radiation such as UV light can be used without limitation.

The photoinitiator may absorb radiation of about 200 to about 420 nm wavelengths in order to initiate cure, although use of initiators that absorb at longer wavelengths, such as the titanocenes that may absorb up to 560 nm, can also be used without restriction.

The total amount of initiator included in the ink composition may be from, for example, about 0.5 to about 15 percent by weight, such as from about 1 to about 10 percent by weight, of the ink composition.

Radiation curable phase change inks generally comprise at least one curable monomer, a gellator, a colorant, and a radiation activated initiator, specifically a photoinitiator, that initiates polymerization of curable components of the ink, specifically of the curable monomer. U.S. Pat. No. 7,279,587 to Odell et al., the disclosure of which is totally incorporated herein by reference, discloses photoinitiating compounds useful in curable solid ink compositions. U.S. Patent Publi-

cation 2007/0120910 to Odell et al., which is hereby incorporated by reference herein in its entirety, describes, in embodiments, a solid ink comprising a colorant, an initiator, and an ink vehicle.

Optionally, the ink compositions can also contain an amine synergist, which are co-initiators which can donate a hydrogen atom to a photoinitiator and thereby form a radical species that initiates polymerization, and can also consume dissolved oxygen, which inhibits free-radical polymerization, thereby increasing the speed of polymerization. Examples of suitable amine synergists include (but are not limited to) ethyl-4-dimethylaminobenzoate, 2-ethylhexyl-4-dimethylaminobenzoate, and the like, as well as mixtures thereof.

Initiators for inks disclosed herein can absorb radiation at any desired or effective wavelength, for example, from about 4 nanometers to about 560 nanometers, or from about 200 nanometers to about 560 nanometers, or from about 200 nanometers to about 420 nanometers, although the wavelength can be outside of these ranges.

Optionally, the photoinitiator is present in the phase change ink in any desired or effective amount, for example from about 0.5 percent to about 15 percent by weight of the ink composition, or from about 1 percent to about 10 percent by weight of the ink composition, although the amount can be outside of these ranges.

## Colorant

In some embodiments, the ink compositions may further optionally comprise colorant. Any desired or effective colorant can be employed in the ink compositions, including dyes, pigments, mixtures thereof, and the like, provided that the colorant can be dissolved or dispersed in the ink vehicle and is compatible with the other ink components. Pigments, which are typically cheaper and more robust than dyes, may be included in the curable phase change ink composition. The color of many dyes can be altered by the polymerization process occurring during the curing stage, presumably from attack of their molecular structure by the free radicals. The compositions can be used in combination with conventional ink-colorant materials, such as Color Index (C.I.) Solvent Dyes, Disperse Dyes, modified Acid and Direct Dyes, Basic Dyes, Sulphur Dyes, Vat Dyes, and the like.

Pigments are suitable colorants for the curable phase change inks. Examples of suitable pigments include PALIOGEN Violet 5100 (commercially available from BASF); PALIOGEN Violet 5890 (commercially available from BASF); HELIOGEN Green L<sub>8730</sub> (commercially available from BASF); LITHOL Scarlet D<sub>3700</sub> (commercially available from BASF); SUNFAST Blue 15:4 (commercially available from Sun Chemical); Hostaperm Blue B2G-D (commercially available from Clariant); Hostaperm Blue B4G (commercially available from Clariant); Permanent Red P-F7RK; Hostaperm Violet BL (commercially available from Clariant); LITHOL Scarlet 4440 (commercially available from BASF); Bon Red C (commercially available from Dominion Color Company); ORACET Pink RF (commercially available from Ciba); PALIOGEN Red 3871 K (commercially available from BASF); SUNFAST Blue 15:3 (commercially available from Sun Chemical); PALIOGEN Red 3340 (commercially available from BASF); SUNFAST Carbazole Violet 23 (commercially available from Sun Chemical); LITHOL Fast Scarlet L4300 (commercially available from BASF); SUNBRITE Yellow 17 (commercially available from Sun Chemical); HELIOGEN Blue L6900, L7020 (commercially available from BASF); SUNBRITE Yellow 74 (commercially available from Sun Chemical); SPECTRA PAC C Orange 16 (commercially available from Sun Chemical); HELIOGEN Blue K6902, K6910 (commercially available from BASF);

SUNFAST Magenta 122 (commercially available from Sun Chemical); HELIOGEN Blue D6840, D7080 (commercially available from BASF); Sudan Blue OS (commercially available from BASF); NEOPEN Blue FF4012 (commercially available from BASF); PV Fast Blue B2G01 (commercially available from Clariant); IRGALITE Blue BCA (commercially available from Ciba); PALIOGEN Blue 6470 (commercially available from BASF); Sudan Orange G (commercially available from Aldrich); Sudan Orange 220 (commercially available from BASF); PALIOGEN Orange 3040 (BASF); PALIOGEN Yellow 152, 1560 (commercially available from BASF); LITHOL Fast Yellow 0991 K (commercially available from BASF); PALIOTOL Yellow 1840 (commercially available from BASF); NOVOPERM Yellow FGL (commercially available from Clariant); Ink Jet Yellow 4G VP2532 (commercially available from Clariant); Toner Yellow HG (commercially available from Clariant); Lumogen Yellow D0790 (commercially available from BASF); Suco-Yellow L1250 (commercially available from BASF); Suco-Yellow D1355 (commercially available from BASF); Suco Fast Yellow D1355, D1351 (commercially available from BASF); HOSTAPERM Pink E 02 (commercially available from Clariant); Hansa Brilliant Yellow 5GX03 (commercially available from Clariant); Permanent Yellow GRL 02 (commercially available from Clariant); Permanent Rubine L6B 05 (commercially available from Clariant); FANAL Pink D4830 (commercially available from BASF); CINQUASIA Magenta (commercially available from DU PONT); PALIOGEN Black L0084 (commercially available from BASF); Pigment Black K801 (commercially available from BASF); and carbon blacks such as REGAL 330™ (commercially available from Cabot), Nipex 150 (commercially available from Degussa) Carbon Black 5250 and Carbon Black 5750 (commercially available from Columbia Chemical), and the like, as well as mixtures thereof.

The colorant may be present in the ink in any desired or effective amount to obtain the desired color or hue such as, for example, at least from about 0.1 percent by weight of the ink to about 50 percent by weight of the ink, or from at least from about 0.2 percent by weight of the ink to about 20 percent by weight of the ink, or at least from about 0.5 percent by weight of the ink to about 10 percent by weight of the ink.

#### Ink Vehicle or Carrier

In some embodiments, the ink compositions may further optionally comprise an ink vehicle or carrier. In specific embodiments, the ink vehicles disclosed herein can comprise any suitable curable monomer or prepolymer. The curable monomer or prepolymer and curable wax together can form more than about 50 percent, or at least 70 percent, or at least 80 percent by weight of the ink. Examples of suitable materials include radically curable monomer compounds, such as acrylate and methacrylate monomer compounds, which are suitable for use as phase change ink carriers. Specific examples of relatively nonpolar acrylate and methacrylate monomers include (but are not limited to) isobornyl acrylate, isobornyl methacrylate, lauryl acrylate, lauryl methacrylate, isodecylacrylate, isodecylmethacrylate, caprolactone acrylate, 2-phenoxyethyl acrylate, isooctylacrylate, isooctylmethacrylate, butyl acrylate, and the like, as well as mixtures and combinations thereof. In addition, multifunctional acrylate and methacrylate monomers and oligomers can be included in the phase change ink carrier as reactive diluents and as materials that can increase the crosslink density of the cured image, thereby enhancing the toughness of the cured images. Examples of suitable multifunctional acrylate and methacrylate monomers and oligomers include, but are not limited to, pentaerythritol tetraacrylate, pentaerythritol tet-

ramethacrylate, 1,2-ethylene glycol diacrylate, 1,2-ethylene glycol dimethacrylate, 1,6-hexanediol diacrylate, 1,6-hexanediol dimethacrylate, 1,12-dodecanol diacrylate, 1,12-dodecanol dimethacrylate, tris(2-hydroxy ethyl)isocyanurate triacrylate, propoxylated neopentyl glycol diacrylate (available from Sartomer Co. Inc. as SR9003), hexanediol diacrylate, tripropylene glycol diacrylate, dipropylene glycol diacrylate, amine modified polyether acrylates (available as PO 83 F, LR 8869, and/or LR 8889 (all available from BASF Corporation), trimethylolpropane triacrylate, glycerol propoxylate triacrylate, dipentaerythritol pentaacrylate, dipentaerythritol hexaacrylate, ethoxylated pentaerythritol tetraacrylate (available from Sartomer Co. Inc. as SR494), and the like, as well as mixtures and combinations thereof. When a reactive diluent is added to the ink carrier material, the reactive diluent is added in any desired or effective amount, for example, from about 1 percent to about 80 percent by weight of the carrier, or from about 35 percent to about 70 percent by weight of the carrier, although the amount of diluent can be outside of these ranges.

In specific embodiments, the ink vehicles disclosed herein can comprise any suitable photoinitiator. Examples of specific initiators include, but are not limited to, IRGACURE® 127, IRGACURE® 379, and IRGACURE® 819, all commercially available from Ciba Specialty Chemicals, among others. Further examples of suitable initiators include (but are not limited to) benzophenones, benzophenone derivatives, benzyl ketones,  $\alpha$ -alkoxy benzyl ketones, monomeric hydroxyl ketones, polymeric hydroxyl ketones,  $\alpha$ -amino ketones, alkoxy ketones, acyl phosphine oxides, metallocenes, benzoin ethers, benzil ketals,  $\alpha$ -hydroxyalkylphenones,  $\alpha$ -aminoalkylphenones, acylphosphine photoinitiators sold under the trade designations of IRGACURE® and DAROCUR® from Ciba, and the like. Specific examples include 1-hydroxy-cyclohexylphenylketone, benzophenone, 2-benzyl-2-(dimethylamino)-1-(4-(4-morpholinyl)phenyl)-1-butanone, 2-methyl-1-(4-methylthio)phenyl-2-(4-morpholinyl)-1-propanone, diphenyl-(2,4,6-trimethylbenzoyl)phosphine oxide, phenyl bis(2,4,6-trimethylbenzoyl)phosphine oxide, benzyl-2-methyl-1-(4-methylthio)phenyl-2-(4-morpholinyl)-1-propanone (available as BASF LUCIRIN® TPO), 2,4,6-trimethylbenzoyl ethoxyphenylphosphine oxide (available as BASF LUCIRIN® TPO-L), bis(2,4,6-trimethylbenzoyl)-phenyl-phosphine oxide (available as Ciba IRGACURE® 819) and other acyl phosphines, 2-methyl-1-(4-methylthio)phenyl-2-(4-morpholinyl)-1-propanone (available as Ciba IRGACURE® 907) and 1-(4-(2-hydroxyethoxy)phenyl)-2-hydroxy-2-methylpropan-1-one (available as Ciba IRGACURE® 2959), 2-benzyl-2-dimethylamino-1-(4-morpholinophenyl)butanone-1 (available as Ciba IRGACURE® 369), 2-hydroxy-1-(4-(4-(2-hydroxy-2-methylpropionyl)-benzyl)-phenyl)-2-methylpropan-1-one (available as Ciba IRGACURE® 127), 2-dimethylamino-2-(4-methylbenzyl)-1-(4-morpholin-4-ylphenyl)-butanone (available as Ciba IRGACURE® 379), titanocenes, isopropylthioxanthone, 1-hydroxy-cyclohexylphenylketone, benzophenone, 2,4,6-trimethylbenzophenone, 4-methylbenzophenone, diphenyl-(2,4,6-trimethylbenzoyl)phosphine oxide, 2,4,6-trimethylbenzoylphenylphosphinic acid ethyl ester, oligo(2-hydroxy-2-methyl-1-(4-(1-methylvinyl)phenyl)propanone), 2-hydroxy-2-methyl-1-phenyl-1-propanone, benzyl-dimethylketal, arylsulphonium slats, aryl iodonium salt, and the like, as well as mixtures thereof.

#### Methods of Use

According to some embodiments, methods are provided for using the curable solid ink for jet printing text. In such

embodiments, the method comprises jetting a curable solid ink onto an intermediate substrate to form an intermediate image, transferring the intermediate image onto a substrate to form a transferred image, and exposing the transferred image to radiation having wavelengths in the range of from about 180 nanometers to about 500 nanometers to cure the curable solid ink. In embodiments, the jetting step is performed at above 70° C., or at from about 70 to about 100° C.

Any suitable printing device may be used herein. In one embodiment, the apparatus is an ink jet printing device as described in commonly assigned, co-pending U.S. Patent Publication No. 2008/0218540, incorporated by reference in its entirety, that includes at least an ink jet print head and a print region surface toward which ink is jetted from the ink jet print head, wherein a height distance between the ink jet print head and the print region surface is adjustable.

The apparatus, as well as the methods herein, may be employed with any desired printing system and marking material suitable for applying a marking material in an image-wise pattern to an intermediate transfer member or directly to an image receiving substrate, piezoelectric ink jet printing (both with inks liquid at room temperature and with phase change inks), acoustic ink jet printing (both with inks liquid at room temperature and with phase change inks), thermal transfer printing, gravure printing, and the like. For the purpose of illustration, a piezoelectric phase change ink jet printer for applying marking material in an imagewise pattern to an intermediate transfer member is described.

The inks can be employed in apparatus for direct printing ink jet processes and in indirect (offset) printing ink jet applications. Another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, and causing droplets of the melted ink to be ejected in an image-wise pattern onto a recording substrate. A direct printing process is also disclosed in, for example, U.S. Pat. No. 5,195,430, the disclosure of which is totally incorporated herein by reference. Yet another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, causing droplets of the melted ink to be ejected in an imagewise pattern onto an intermediate transfer member, and transferring the ink in the imagewise pattern from the intermediate transfer member to a final recording substrate. In a specific embodiment, the intermediate transfer member is heated to a temperature above that of the final recording sheet and below that of the melted ink in the printing apparatus. In another specific embodiment, both the intermediate transfer member and the final recording sheet are heated; in this embodiment, both the intermediate transfer member and the final recording sheet are heated to a temperature below that of the melted ink in the printing apparatus; in this embodiment, the relative temperatures of the intermediate transfer member and the final recording sheet can be (1) the intermediate transfer member is heated to a temperature above that of the final recording substrate and below that of the melted ink in the printing apparatus; (2) the final recording substrate is heated to a temperature above that of the intermediate transfer member and below that of the melted ink in the printing apparatus; or (3) the intermediate transfer member and the final recording sheet are heated to approximately the same temperature. In one specific embodiment, the printing apparatus employs a piezoelectric printing process wherein droplets of the ink are caused to be ejected in imagewise pattern by oscillations of piezoelectric vibrating elements. Inks as disclosed herein can also be employed in other hot melt printing processes, such as hot melt acoustic ink jet printing, hot melt

continuous stream or deflection ink jet printing, and the like. Phase change inks as disclosed herein can also be used in printing processes other than hot melt ink jet printing processes.

Any suitable substrate or recording sheet can be employed, including plain papers such as XEROX 4200 papers, XEROX Image Series papers, Courtland 4024 DP paper, ruled notebook paper, bond paper, silica coated papers such as Sharp Company silica coated paper, JuJo paper, HAMMERMILL LASERPRINT paper, and the like, glossy coated papers such as XEROX Digital Color Gloss, Sappi Warren Papers LUS-TROGLOSS, specialty papers such as Xerox DURAPAPER, and the like, transparency materials, fabrics, textile products, plastics, polymeric films, inorganic recording mediums such as metals and wood, and the like, transparency materials, fabrics, textile products, plastics, polymeric films, inorganic substrates such as metals and wood, and the like.

According to some embodiments, there is provided a method of jet printing an image, comprising: jetting a curable solid ink onto a print substrate to form an image; and exposing the image to radiation to cure the curable solid ink on to the print substrate, wherein the curable solid ink comprises a curable wax, an optional non-curable component, one or more monomers, an optional colorant, a gellant oligomer mixture composition of the present embodiments, and a photoinitiator.

It will be appreciated that various of the above-disclosed and other features and functions, or alternatives thereof, may be desirably combined into many other different systems or applications. Also, various presently unforeseen or unanticipated alternatives, modifications, variations or improvements therein may be subsequently made by those skilled in the art, and are also intended to be encompassed by the following claims.

While the description above refers to particular embodiments, it will be understood that many modifications may be made without departing from the spirit thereof. The accompanying claims are intended to cover such modifications as would fall within the true scope and spirit of embodiments herein.

The presently disclosed embodiments are, therefore, to be considered in all respects as illustrative and not restrictive, the scope of embodiments being indicated by the appended claims rather than the foregoing description. All changes that come within the meaning of and range of equivalency of the claims are intended to be embraced therein.

## EXAMPLES

The examples set forth herein below and are illustrative of different compositions and conditions that can be used in practicing the present embodiments. All proportions are by weight unless otherwise indicated. It will be apparent, however, that the present embodiments can be practiced with many types of compositions and can have many different uses in accordance with the disclosure above and as pointed out hereinafter.

### Example 1

#### Synthesis of Crystalline Gellant Amide 1

To a 1000 mL 3-necked round bottom flask with condenser in the middle neck, a glass stopper in each of the other 2 outside necks, N<sub>2</sub> blowing through top of condenser and Teflon coated magnet was added about 100.0 g (0.35 mol) isostearic acid (Prisorine 3505 from Uniqema). The reaction

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flask was placed in a 120° C. oil bath and stirring was initiated. After about 5 minutes, 19.7 grams (0.17 mol, 0.5 eq) of trans-1,2-diaminocyclohexane (from Aldrich Chemical Company) was added through one of the side arms. The reaction mixture was allowed to stir for about 10 minutes at 120° C. The oil bath temperature controller was then increased to 190° C. and the reaction mixture stirred for about 1 hour after reaching this temperature. The condenser was then replaced with a glass stopper (in the middle neck), a distillation setup was attached to one of the outside necks and a N<sub>2</sub> stream attached to the other neck. The N<sub>2</sub> distilled off the water while the reaction mixture stirred at 190° C. for an additional 2 hours. The N<sub>2</sub> stream, via a glass pipette, was gently bubbled subsurface for about 1 hour and removed. The reaction product was then poured into aluminum tins and allowed to solidify as a rubbery brown solid.

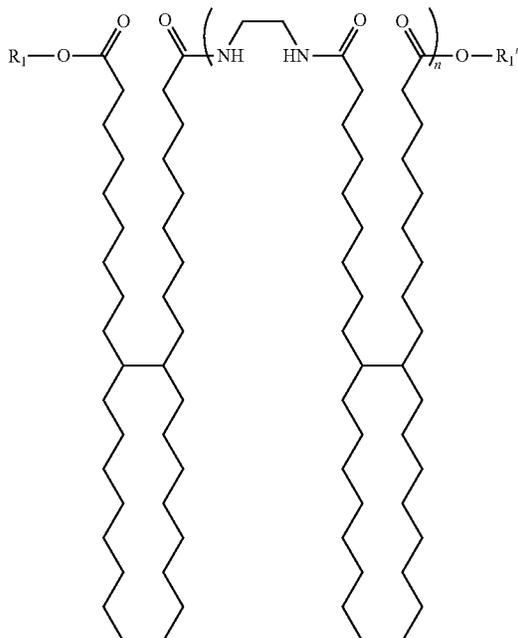
## Example 2

## Rheological Behavior

The rheological and thermal characterization of the crystalline gellant amide 1 is shown in FIGS. 2, 3, and 4.

FIG. 2 shows the differential scanning calorimetry (DSC) of crystalline amide gellant 1.

FIG. 3 is a rheological profile showing the complex viscosity of two amorphous oligomer gellants 2 and 3 vs. crystalline amide gellant 1. The amorphous oligomer gellant 2 contains low molecular weight amide gellant having a weight average molecular weight (Mw) of 800-2500, and a number average molecular weight (Mn) of 500-2500. The amorphous oligomer gellant 3 contains medium molecular weight amide gellant having a weight average molecular weight (Mw) of 2500-3000, and a number average molecular weight (Mn) of 1200-1700.



wherein n is 1 to 10; and R<sub>1</sub> and R<sub>1</sub>' are each phenylglycol.

FIG. 4 is a measure of the G' and G'' of two amorphous oligomer gellants 2 and 3 vs. crystalline gellant 1. It is found that the crystalline amide gellant 1 has higher G'' values than G' values at room temperature, this is reflected in the tan δ or

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ratio of G''/G'. The crystalline amide gellant 1 has a tan δ of 1.487. The amorphous oligomer gellants 2 and 3 have tan δ of 0.039 and 0.058 respectively. It is therefore noted that for crystalline amide gellant 1, tan δ is much higher (1.487) than the amorphous oligomer gellants 2 and 3 (tan δ=0.039-0.058).

## Example 3

## Energy-Minimized Structure

The molecular mechanics (MM2) 3-D structures of the energy-minimized structures of amorphous oligomer gellants 2 and 3 vs. crystalline amide gellant 1 were generated, which are shown in FIGS. 5 and 6. It is shown a more spread-out, regular structure of crystalline amide gellant 1, which supports the evidence for crystalline nature.

It has been found that the cyclohexyl-based crystalline gellant of the present embodiments exhibits unique properties. The cyclohexyl-based crystalline gellant of the present embodiments is a rubbery solid that has low viscosity at elevated temperature, yet crystalline at low temperatures. Furthermore, this material is an enabler for non-contact leveling of ink.

## Ink Formulations

Table 1 provides the ink formulation for a curable solid ink using the standard gellant (Ink A). Table 2 provides the ink formulation for a curable solid ink using crystalline gellant of the present embodiments (Ink B).

TABLE 1

Ink A		
Component	Wt percent	Mass (g)
Standard Amide Gellant (PPAGel-17)	7.5	18.8
Unilin 350 acrylate (PP-U350Ac-4)	5	12.5
SR833S	61.47	153.7
SR399LV	5.0	12.5
Irgacure 379	3	7.5
Irgacure 819	0.5	1.3
Esacure KIP150	4	10.0
Irgastab UV10	0.2	0.5
15 wt percent cyan pigment dispersion/SR9003	13.3	33.3
TOTAL	100	250

TABLE 2

Ink B		
Component	Wt percent	Mass (g)
Crystalline Amide Gellant 1	7.5	18.8
Unilin 350 acrylate (PP-U350Ac-4)	5	12.5
SR833S	61.47	153.7
SR399LV	5.0	12.5
Irgacure 379	3	7.5
Irgacure 819	0.5	1.3
Esacure KIP150	4	10.0
Irgastab UV10	0.2	0.5
15 wt percent cyan pigment dispersion/SR9003	20	33.3
TOTAL	100	250

## Printed Ink Images

Inks were printed using a Typhoon printhead (available from Xerox Corp.) on two different substrates, coated papers and plastic: SG Elite (Silk Gloss Elite coated paper) and

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BOPP (biaxially oriented polypropylene plastic film). Photographs were taken through a microscope to qualitatively assess the uniformity. The three particular defects to look for were: ragged or dotted "Morse code" lines (indicative of poor leveling), and white gaps between printed lines (also indicative of poor leveling).

FIGS. 7 and 8 are optical micrographs showing a comparison of two inks printed on BOPP substrate, Biaxially Oriented PolyPropylene (a plastic film): one containing the standard amide gellant (Ink A, on the left), and one with the crystalline amide gellant of the present embodiments (Ink B, on the right). As shown in FIGS. 7 and 8, Ink B exhibited smoother printed images, greater uniformity, and virtually no Morse Code pattern on the printed line.

## SUMMARY

In summary, the present embodiments provide cyclohexyl-based crystalline gellants with unique rheological properties and the method of making thereof. There is also provided UV curable inks comprising cyclohexyl-based crystalline gellants which have demonstrated the ability to self-level in a non-contact mode.

The claims, as originally presented and as they may be amended, encompass variations, alternatives, modifications, improvements, equivalents, and substantial equivalents of the embodiments and teachings disclosed herein, including those that are presently unforeseen or unappreciated, and that, for example, may arise from applicants/patentees and others. Unless specifically recited in a claim, steps or components of claims should not be implied or imported from the specification or any other claims as to any particular order, number, position, size, shape, angle, color, or material.

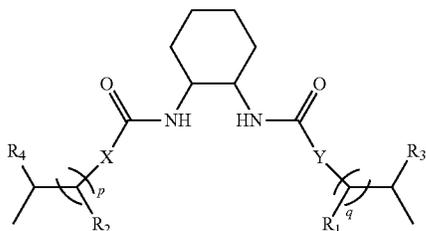
All the patents and applications referred to herein are hereby specifically, and totally incorporated herein by reference in their entirety in the instant specification.

What is claimed is:

1. A self-leveling curable solid ink comprising:

a curable wax;

a cyclohexyl-based crystalline gellant having the following formula:



wherein each X and Y is independently CH<sub>2</sub> or O; each p and q is independently from about 8 to about 20; each R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, and R<sub>4</sub> is independently H or lower alkyl; wherein the cyclohexyl-based crystalline gellant has a tan δ above about 0.08, and a melting point of above about 90° C.

2. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant having a tan δ of from about 0.8 to about 2.

3. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant having a melting point of from about 90° C. to about 150° C.

4. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant has a G' at room

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temperature of from about 1 Pa to about 100 Pa and a G'' at room temperature of from about 1 Pa to about 100 Pa.

5. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant has a melting temperature of from about 90° C. to about 150° C.

6. The self-leveling curable solid ink of claim 1, wherein the self-leveling curable solid ink having a gel point of from about 35° C. to about 70° C.

7. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant is present in the curable solid ink in an amount of from about 1 percent to about 50 percent.

8. The self-leveling curable solid ink of claim 1, wherein the cyclohexyl-based crystalline gellant is present in the curable solid ink in an amount of from about 5 percent to about 10 percent.

9. The self-leveling curable solid ink of claim 1, wherein both X and Y are CH<sub>2</sub>.

10. The self-leveling curable solid ink of claim 1, wherein p is from about 10 to about 18.

11. The self-leveling curable solid ink of claim 1, wherein q is from about 10 to about 18.

12. The self-leveling curable solid ink of claim 1, wherein both R<sub>3</sub> and R<sub>4</sub> are methyl.

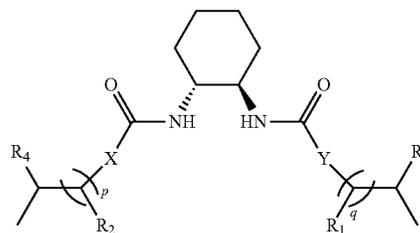
13. The self-leveling curable solid ink of claim 1, wherein each one of R<sub>1</sub> and each one of R<sub>2</sub> is H.

14. A self-leveling curable solid ink comprising a curable wax;

a cyclohexyl-based crystalline gellant; and

a photoinitiator;

wherein the cyclohexyl-based crystalline gellant has the following formula:



wherein each X and Y is independently CH<sub>2</sub> or O; each p and q is independently from about 8 to about 20; each R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub> and R<sub>4</sub> is independently H or lower alkyl; and

wherein the cyclohexyl-based crystalline gellant has a tan δ above about 0.08, and a melting point of above about 90° C.

15. The self-leveling curable solid ink of claim 14, wherein the cyclohexyl-based crystalline gellant has a melting point of from about 90° C. to about 150° C.

16. The self-leveling curable solid ink of claim 14, wherein the cyclohexyl-based crystalline gellant has a tan δ of from about 0.8 to about 2.

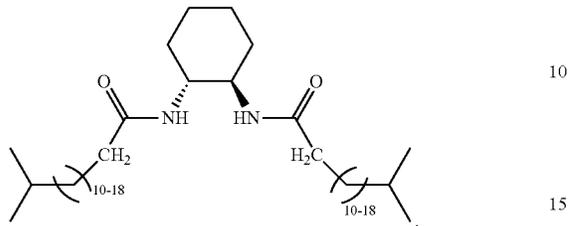
17. The self-leveling curable solid ink of claim 14, wherein the cyclohexyl-based crystalline has a G' at room temperature of from about 1 Pa to about 100 Pa and a G'' at room temperature of from about 1 Pa to about 100 Pa.

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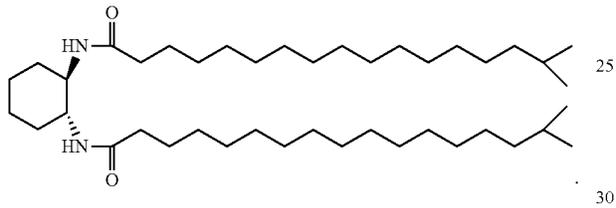
18. A self-leveling curable solid ink comprising  
 a curable wax; and  
 a cyclohexyl-based crystalline gellant;  
 wherein the cyclohexyl-based crystalline gellant has the fol-  
 lowing formula:

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19. The self-leveling curable solid ink of claim 18, wherein  
 the cyclohexyl-based crystalline gellant has the following  
 formula:

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